

5/40

DART AEROSPACE LTD	Work Order:	24097
Description: End Plate	Part Number:	D3067-1
Drawing: D3067 Rev. A	Qty:	159
Page 1 of 1		

RF 02/10/17


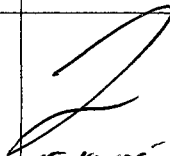
Stack of 8

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveller	TH	05.08.23	160
2	MV	Cut blanks 2.750" x 3.030" +/- 0.005 Grain along 2.750" Material: 5052-H32 (QQ-A-250/8) (M5052H32S.063) or 6061-T6 (QQ-A-250/11) (Ref. M6061T6S.063) Batch: M116454	gml	05/09/22	160
3	MV	Machine per folio FA183 and Dwg D3067	gml	05/09/23	160
4	QC2	Inspect parts as they come off the CNC machine	gml	05/09/23	160
5	QC7	Second inspection	Er	05/09/23	160
6	MV	Deburr			
7	GB	Bend as per Dwg D3067	SR	05/10/05	159
8	QC5	Inspect work to Step 7	J	05-10-05	155
9	WA	Identify and stock	J	05-10-05	155
10	AC	Cost / Part , 87	SAC	05-10-06	159
11	DC	Close W/O , 98 Inspect level 21	LD	05/10/06	159

Rev	Date	Change	Revised By	Approved
A	01.12.10	New Issue	EC	
B	02.01.03	Now machined on HAAS	SM	
C	02.10.04	Re-format	KJ RF	
C1	03.01.21	Remove step 6 (Deburr)	RF	

RELEASED
02/10/15 RF

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05-10-05	8	No parts scrapped during bending?? missing 1 end plate.		count AS <u>159</u>		 05-10-05		 05-10-05

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA:  Date: 05/10/06

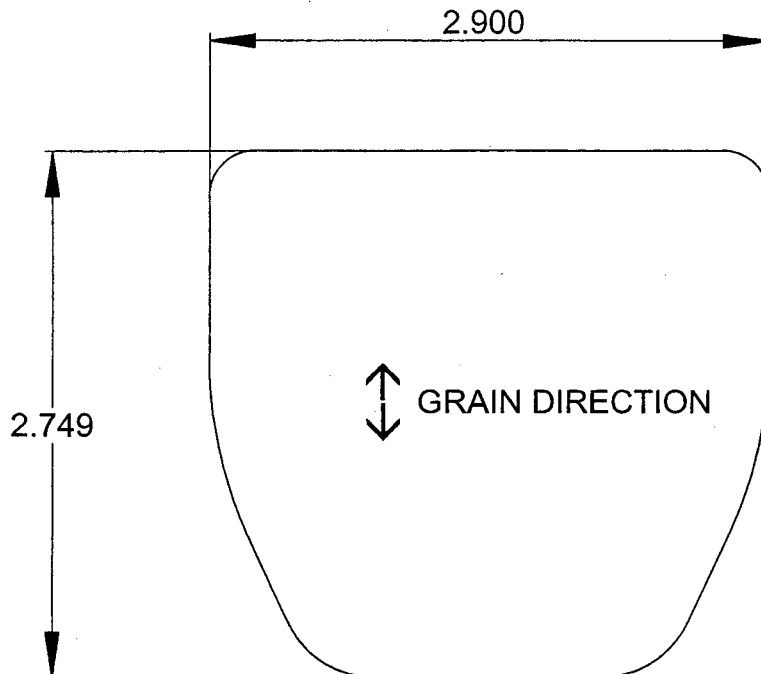
NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

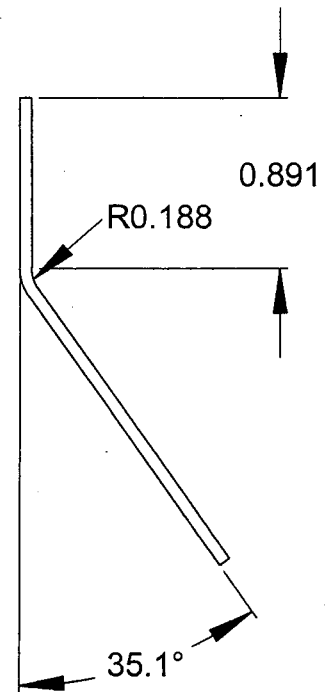


DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CP</i>	APPROVED <i>CP</i>	DRAWING NO. D3067	REV. A SHEET 1 OF 1
DATE 02.09.11		TITLE END PLATE	SCALE 1:1
A	02.09.11	NEW ISSUE	

RELEASED
02.09.2011



D3067-1 FLAT PATTERN



D3067-1 BEND DETAIL

D3067-1 END PLATE

- 1) MACHINE PER DWG FILE "D3067-1.SLDPRT"
- 2) MATERIAL: 5052-H32 PER QQ-A-250/8 (REF DART SPEC. M5052H32S.063)
OR 6061-T6 PER QQ-A-250/11 (REF DART SPEC. M6061T6S.063)
ALUMINUM SHEET, 0.063 THICK
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

SHOP COPY
RETURN TO
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S. T. ENDMENT
WITHOUT NOTICE

WORK ORDER
NO. 24097

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Aug 18, 2005
10:59 am

Work Order No : 0024097
Project Name : D3067-1
Project For : WK540
Work Order Type : Main
Main WO Number :
House Part Number : D3067-1
Description : End Plate
Manufactured : Yes
Amount Req'd : 160
Amount Done : 0
Start Date : 08-17-05
Est Finish Date :
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Mark Up : 0.000%
Actual Mark Up : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00		
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	0.00	0.00		
Mark up	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00